

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029046**Date Inspected:** 24-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** Crest Hill, IL

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Elevator-Landing Gate Material/ Cab				

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative, Dustyn Broening was present at USA Hoist in Crest Hill, Illinois for the purpose of providing Quality Assurance observations on items related to CCO85.

At the time of arrival, this QA Inspector met with Tim Moran, USA Hoist Project Manager and observed current shop operations. Employees are performing work on material consisting of C180 x 18.2 (from heat #Y017071) and C200 x 20.5 (from heat #A068499 and heat #1110874) and L64 x L64 x 9.5 angles (from heat #J18913. This QA inspector also met with QA inspector Joseph Lizardo and provided Mr. Lizardo the pertinent turnover information throughout the day.

This QA observed USA Hoist employee, Matt Wasiqi, preparing assembly piece #914930 Channels to Angle joints with proper bevels for the fit up of the Complete Joint Penetration (CJP) weldments. CJP FCAW process, will utilize USA Hoist company Welding Procedure Specification (WPS) identified as FCAW2915 B-U3-GF. USA Hoist employees, Genaro Ulloa and Matt Wasiki have satisfactorily fit up two (2ea) Door Enclosure Weldment Assemblies piece #914930 Weldment on the work bench with the use of C-clamps for holding the frame in position during the welding process. Approved Welder Matt Wasiki performed FCAW process (E71T-1C) CJP welds in the 1G position, on the Channels piece #'s 914930 and #914911 to Angle piece #914900-02. This QA randomly observed the welders electrical parameters and noted the Voltage to be at 28V and Amperage to be 220A, which was within the specified parameters of the specified WPS. Backgouges to sound metal were performed and observed by this QA and were noted to be Visually acceptable. This QA performed random dimensional inspections on the work performed above which appeared to be in general conformance with

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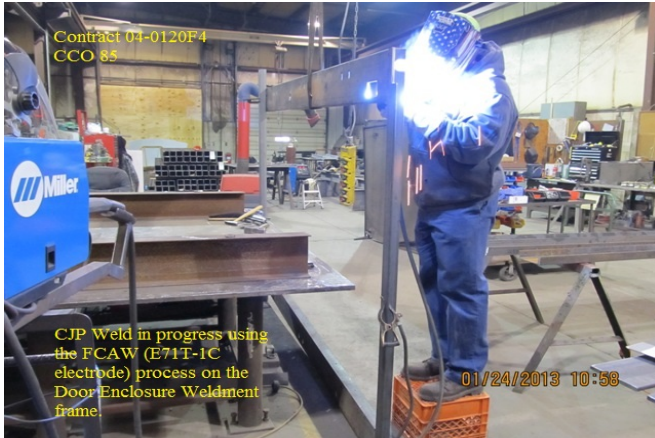
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the project plans and specifications. Welding of Backgouged area and final ground smooth preparation is pending as of this date.

Also attached to this report are digital photographs of the QA Inspector's observations.



## Summary of Conversations:

Any significant conversations are noted above, other basic communication regarding schedule and the task at hand was performed between this QA Inspector and Mr. Moran during this visit.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Broening,Dustyn

Quality Assurance Inspector

**Reviewed By:** Riley,Ken

QA Reviewer

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